

5/18

W/O

SPLIT

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23001 B</b>
<b>Description: Hub Sleeve</b>	<b>Part Number:</b>	<b>D3233-5</b>
<b>Dwg: D3233 Rev. B</b>	<b>Qty:</b>	<b>34 26</b>
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.04.13	34
2	CL	Turn as per Dwg D3233 Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020 SRA or AMS 5075 or AMS 5077 (M1020TR1.875W.250) Identify for D3233-5	J.G	05/06/14	34
		Batch: <u>M17015</u>			
3	QC2	Inspect parts as they come off the machine Identify as D3233-5	J.G	05/06/15	34
4	CM	Mill as per Dwg D3233	BG	05.06.21	26
5	QC8	Second check	En	05.6.21	26
6	CM	Deburr	BG	05.06.21	26
7	QC5	Inspect work to Step 6	J	05.06.22	26
8	ST	Identify and Stock	CPL	05.06.23	26
9	AC	Cost / part <u>7.13</u>	J.G	05.06.24	26
10	DC	Close W/O <u>6.13</u> Inspect Level 21	HA	05.06.27	26

Rev	Date	Change	Revised By	Approved
A	05.03.14	New issue	KJ/JLM	

RELEASED  
05/05/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

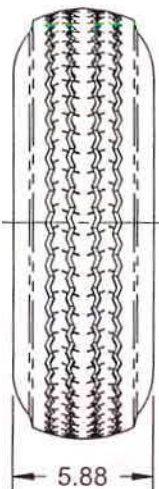
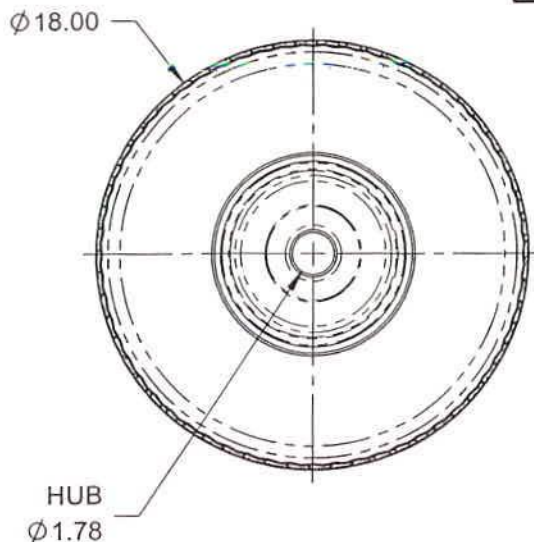
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED  
*[Signature]*  
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

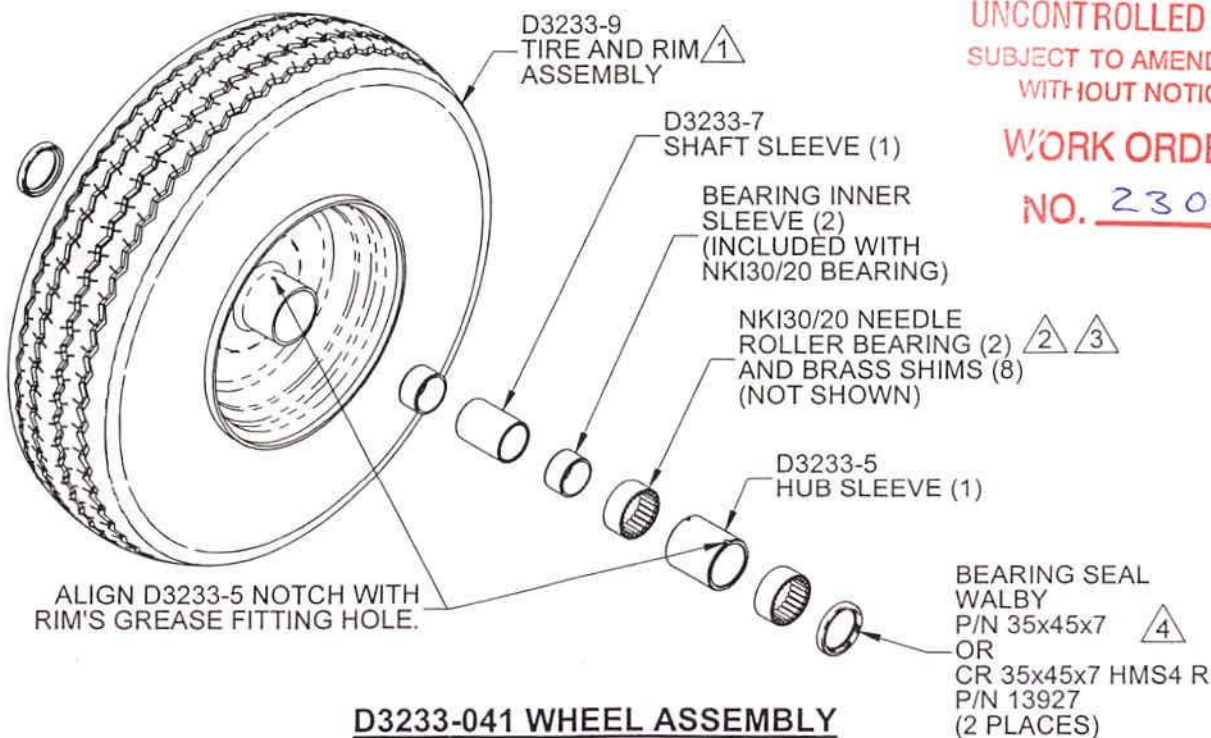
\* MANUFACTURER'S RECOMENDATIONS  
ARE 75 PSI FOR HIGH SPEED USE.

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WORK ORDER

NO. 23001B



### D3233-041 WHEEL ASSEMBLY

#### NOTES:

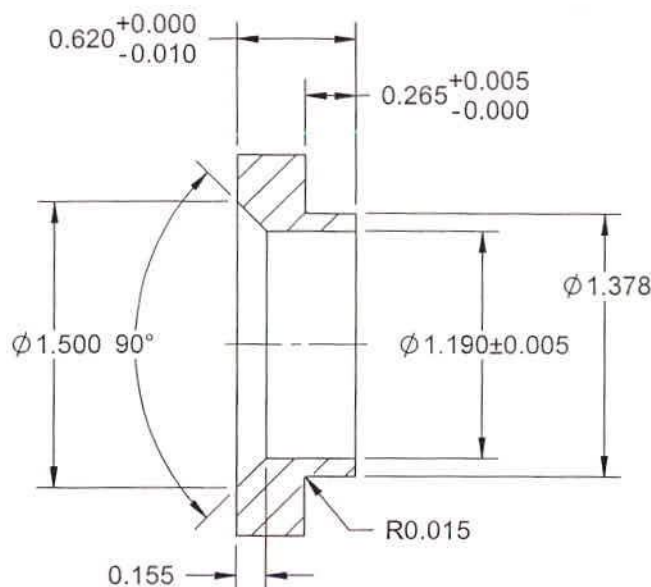
- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH  
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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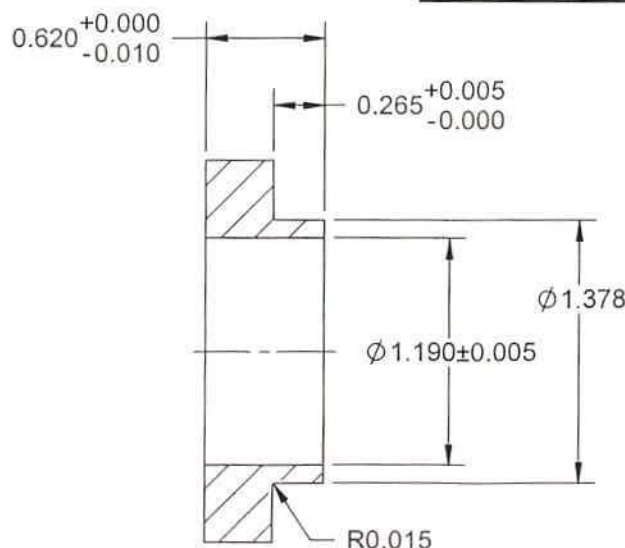


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DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1



SECTION A-A

D3233-1 INSIDE WASHER



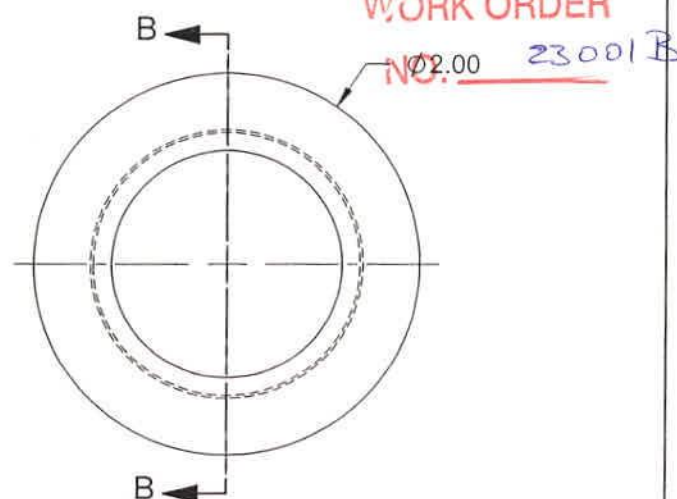
SECTION B-B

D3233-3 OUTSIDE WASHER



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WORK ORDER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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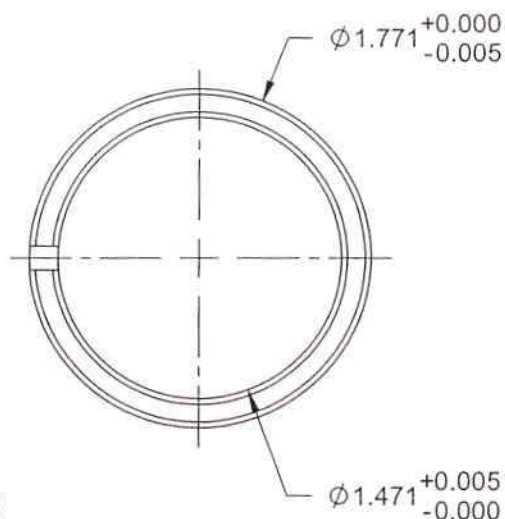
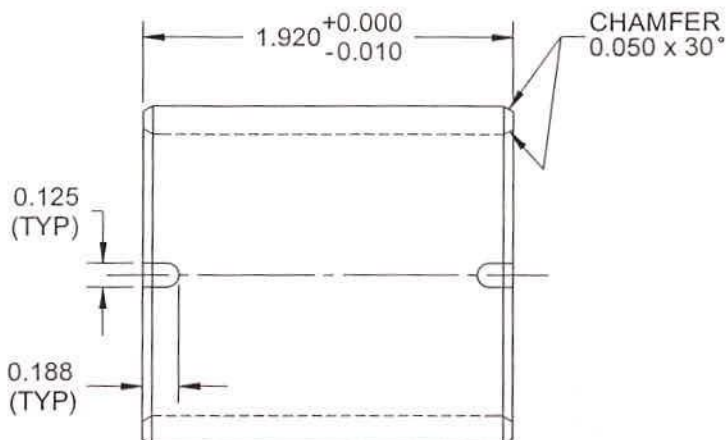
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

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*[Signature]*  
05/05/04



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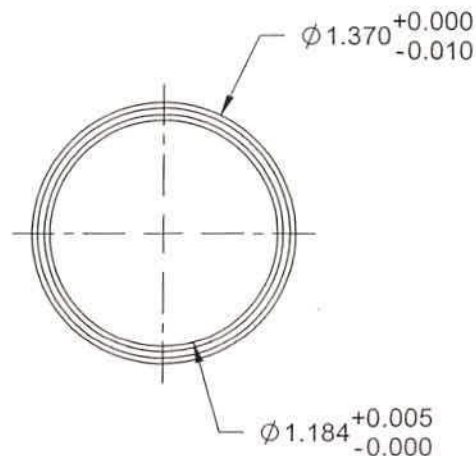
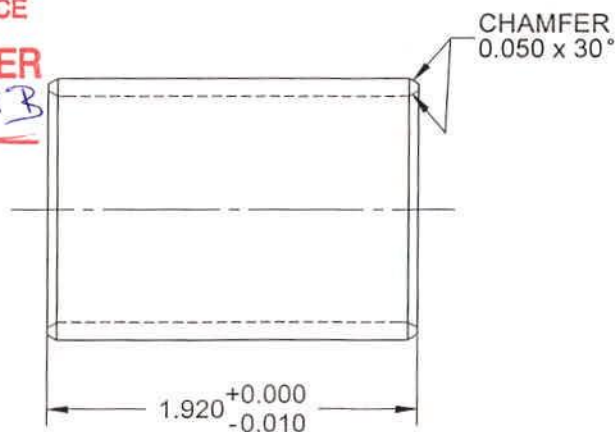
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### D3233-5 HUB SLEEVE

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WORK ORDER

NO. 230013



### D3233-7 SHAFT SLEEVE

#### NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 12, 2005  
02:25 pm

Work Order No : 0023001  
Project Name : D3233-5  
Project For : WK518  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3233-5  
Description : Hub Sleeve  
Manufactured : Yes  
Amount Req'd : 34  
Amount Done : 0  
Start Date : 04-12-05  
Est Finish Date : 04-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00